

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-015522**Date Inspected:** 27-Jun-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** ZPMC and ABF**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance (QA) Inspector Mr. Wai Pau, was present during the times noted above for observations relative to the work being performed.

Bay#5

Travel rail beam: -Caltrans QA inspector observed a ZPMC welder performed SMAW build up weld metal (buttering) process on the flange of traveler rail #11TR1-016. The buttering areas are located both ends of top and bottom flanges. The buttering size is along the both edge ends of flanges with 10mm width. All of buttering areas have been pre-heating to specific desired temperature prior SMAW welding. The SMAW process were monitored and recorded by ZPMC and ABF QC inspector. Based on Caltrans QA Inspector observations, no discrepancies were noted.

Travel rail beam: -Caltrans QAI observed two ZPMC heat straightening operators performed heat straightening with ZPMC Heat Straightening Report on travel rail beams. The travel rail beams ID are 11TR1-016, 11TR3-016, 11TR2-016 and 10TR2-012. The heating temperature is maximum 650 C (1200 F) and cool in still air. All the plates for heat straightening have been inspected and recorded by ZPMC QC. Based on Caltrans QAI observation, no discrepancies were noted.

Bay#6

Bottom and side plate: - Caltrans QA inspector performed final dry MT inspection on stiffener fillet welds of deck plate and side plates. The fillet weld is connected to the stiffeners, deck plate and side plate. The deck plate and side plate ID and weld number are DP3142-001-1~8 and SP3058-001-1~10. The welds for dry MT inspection have been accepted by ZPMC prior Caltrans QA inspection. Base on Caltrans MT inspection, the welds appeared

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to be in compliance with requirements of AWS D1.5 2002 and Caltrans contract documents.

Bay#7

Caltrans QA Inspector observed two welding operators in process of semi-automatic FCAW on stiffeners. The stiffener weld is designed PJP with T-joint weld and located on the side plate. The side plate and stiffener weld ID is SP3093A/SP3093A-001-030~041. All of PJP joint regions have been pre-heating to specific desired temperature prior welding. The semi-automatic FCAW process was monitored and recorded by ZPMC and ABF QC inspector. Based on Caltrans QAI observations, no discrepancies were noted.

Bay# 8

Cross beam: - Caltrans QA inspector observed a ZPMC welder performed FCAW CJP process on the flange to flange for floor beam of cross beam # CB17. The weld ID is FB3058-056-030. The region of the weld joint has been pre-heating to specific desired temperature prior FCAW welding. The FCAW process were monitored and recorded by ZPMC and ABF QC inspector. Based on Caltrans QA Inspector observations, no discrepancies were noted.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

Summary of Conversations:

As notes within report above



Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang 15000422372 , who represents the Office of Structural Materials for your project.

Inspected By:	Pau,Wai	Quality Assurance Inspector
Reviewed By:	Clifford,William	QA Reviewer
